

Work Order ID 83675

83675

April-23-12 11:13:04 AM

Ship May 15th
Page 1

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly (350)
Start Date: 23/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 07/05/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 12/04/23 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

IX _____ SD
12-5-11
1 φ BL 12-5-15
⊙

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Item Name: Long Basket Assembly (350)
 Start Date: 23/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 07/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

83 673

10

12/5/16

MLJ 12/05/16

*unc
12-05-16*

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D4030-041

Required Date: 07/05/2012

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-
1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200 *D4086-200* Placard, Max Load		Manufactured	No				Each	17.0000					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST122				17					
					72051			1					
					82827			16					
D2530 *D2530* Handle Weldment		Manufactured	No				100	Each	3.0000				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				3					
					77030			1					
					82150			2					
D2535 *D2535* Spring		Manufactured	No				100	Each	10.0000				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				10					
					77488			10					
D2537 *D2537* Bushing		Manufactured	No				100	Each	0.0000				

Dart Aerospace Ltd

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Work Order ID: 83675

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

83675

D4030-041

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-041	Manufactured	No	82535	100	Each	0.0000	1	1	**	1	BL 12-5-15.
D3913-041											
Long Basket Base Assembly, 350											
D3914-041	Manufactured	No	82536.	100	Each	0.0000	1	1	**	1	PL 12-5-15.
D3914-041											
Long Basket Lid Assembly (350)											
D3917-3	Manufactured	No		100	Each	43.0000	6	6	**	6	B 82736 SP
D3917-3											
Washer											

Location	Loc Qty	Loc Code
ST070	43	
76956	4	
80598	1	
81205	38	

D3953-3	Manufactured	No		100	Each	52.0000	2	2	**	2	SP
D3953-3											
Gas Spring Stud, Lid											

Location	Loc Qty	Loc Code
ST075	52	
82044	12	
82939	40	

D3953-7	Manufactured	No		100	Each	62.0000	2	2	**	2	SP 12-5-11
D3953-7											
Spring Spacer											

Location	Loc Qty	Loc Code
ST075	62	
82045	22	
82940	40	

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each 74.0000 2 2

D3953-9

Gas Spring Washer

**

Location

Loc Qty

Loc Code

ST075

74

82035

34

82941

40

D3953-17 Manufactured No

100 Each 54.0000 2 2

D3953-17

Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

54

81206

13

82937

41

D3953-19 Manufactured No

100 Each 53.0000 1 1

D3953-19

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

53

75227

1

82938

52

D3953-21 Manufactured No

100 Each 18.0000 1 1

D3953-21

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

18

81207

12

81456

6

W/O:		WORK ORDER CHANGES					
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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3

Manufactured No

100

Each

61.0000

1

1

D3969-3

Spring (Basket Lid)

**

SP

Location

Loc Qty

Loc Code

ST272

61

64285

1

73515

5

81887

15

82942

40

1x

AN3-14A

Purchased

No

100

Each

99.0000

4

4

AN3-14A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST352

99

119328

44

121415

30

121444

25

4x

AN3-16A

Purchased

No

100

Each

101.0000

2

2

AN3-16A

Bolt

**

SP 12-5-11

Location

Loc Qty

Loc Code

ST352

101

117441

47

118628

4

120986

50

2x

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 83675

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

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D4030-041

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A	Purchased	No	100	Each	110.0000	4	4
AN5-17A						**	SP12-5-11
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
338	76	
121181	76	
ST338	34	
117872	34	

AN4-12	Purchased	No	100	Each	50.0000	3	3
AN4-12						**	SP
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	50	
118626	1	
119775	25	
120986	24	

AN310-4	Purchased	No	100	Each	97.0000	3	3
AN310-4						**	SP12-5-11
NUT							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST344	97	
120124	1	
120518	25	
121011	1	
121162	20	
121349	25	
121444	25	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4	Purchased	No	100	Each	83.0000	2	2
AN310C4						**	
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST344	83	
120360	30	
121166	28	
121444	25	

MS21042L3	Purchased	No	100	Each	3,551.000	6	6
MS21042L3						**	
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3551	
117441	16	
117885	32	
118451	5	
118927	3	
119017	1411	
119075	158	
121349	926	
121444	1000	

MS21042L5	Purchased	No	100	Each	1,351.000	4	4
MS21042L5						**	
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1351	
116105	5	
116548	43	
117611	30	
119109	1273	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 83675

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

83675

D4030-041

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

263.0000

3

3

MS24665-151

Cotter Pin

**

SP

Location

Loc Qty

Loc Code

ST309

263

17566

263

3x

MS24665-300

Purchased

No

100

Each

183.0000

2

2

MS24665-300

Cotter Pin

**

SP

Location

Loc Qty

Loc Code

GA

179

118234

179

2x

ST309

4

116823

4

NAS1149F0432P

Purchased

No

100

Each

1,226.000

6

6

NAS1149F0432P

Washer

**

m121415 SP

Location

Loc Qty

Loc Code

ST275

1226

121255

26

121350

1000

121415

200

NAS1149F0563P

Purchased

No

100

Each

1,041.000

4

4

NAS1149F0563P

Washer

**

SP 12-5-11

Location

Loc Qty

Loc Code

ST275

1041

117735

41

121350

1000

4x

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Shop Packet Print

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Work Order ID: 83675

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

568.0000

8

8

NAS1149F0332P

WASHER

**

m 12/585 8x
8p

Location

Loc Qty

Loc Code

ST275

568

117735

25

119225

10

120910

130

120986

200

~~121259~~

200

17317

3

NAS1149C0432R

Purchased

No

100

Each

4,774.000

2

2

NAS1149C0432R

Washer

**

8p 12-5-11

Location

Loc Qty

Loc Code

ST297

1810

~~117291~~

810

119124

1000

ST298

2964

121255

2964

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

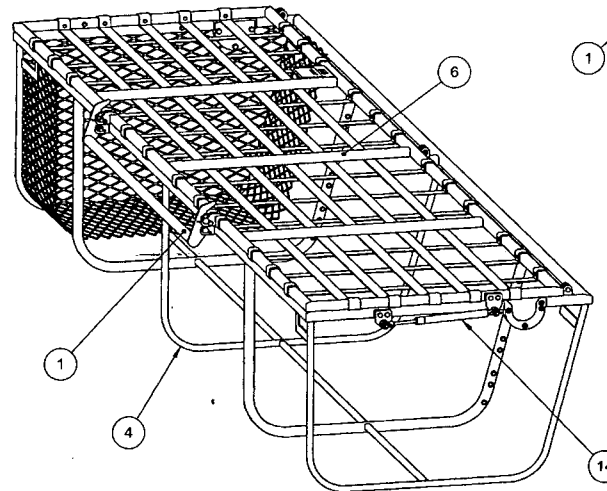
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT

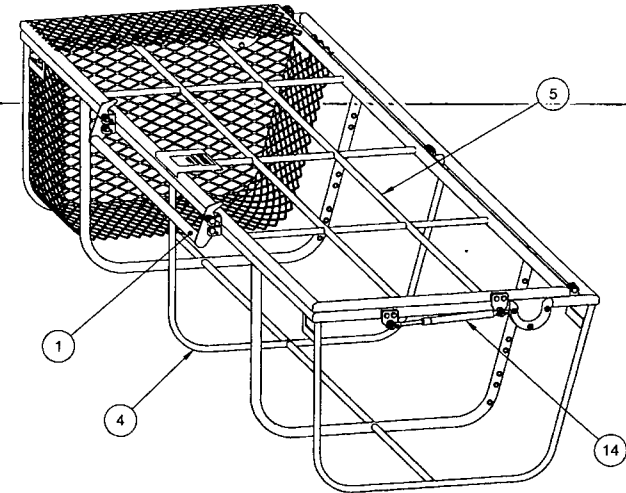
WITHOUT NOTICE

WORK ORDER

NO. 83675 MLJ
12/04/23



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-17
ECN 10-596

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (BB-1); QTY FOR ITEM #3 WAS 4 (DB-1); ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 1 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	#	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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C8-3 A

A C8-3

B C6-3

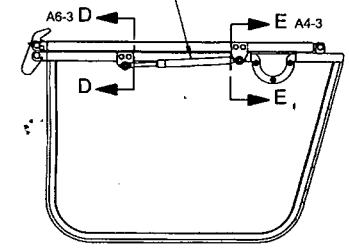
83675

D2530
HANDLE WELDMENT

SEE
SECTION C-C
C3-3

D4030-041: D3914-041 LID ASSY
D4030-043: D3915-041 LIGHT LID ASSY

D3969-3 SPRING



D3913-041
LONG BASKET BASE ASSY

D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	SES	D4030	SHEET 2 OF 3
APPROVED	NY	TITLE	SCALE
DE APPR.	NY	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

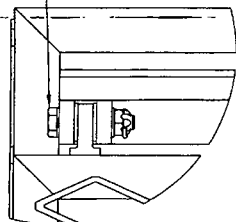
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

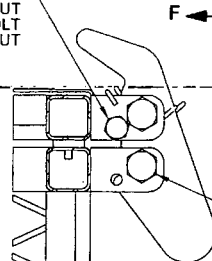
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL A D8-2
D5-2

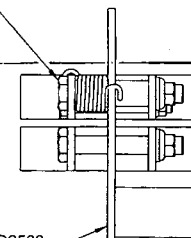
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

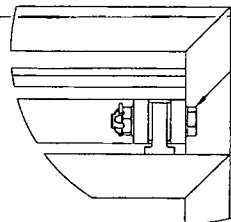
D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.12.4

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	J.F.S.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J.F.S.	DRAWING NO.	REV. C
MFG. APPR.	J.F.S.	D4030	SHEET 3 OF 3
APPROVED	J.F.S.	TITLE	SCALE
DE APPR.	J.F.S.	LONG BASKET-ASSY (350)	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries